


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	4/28/2017	SM	JAG

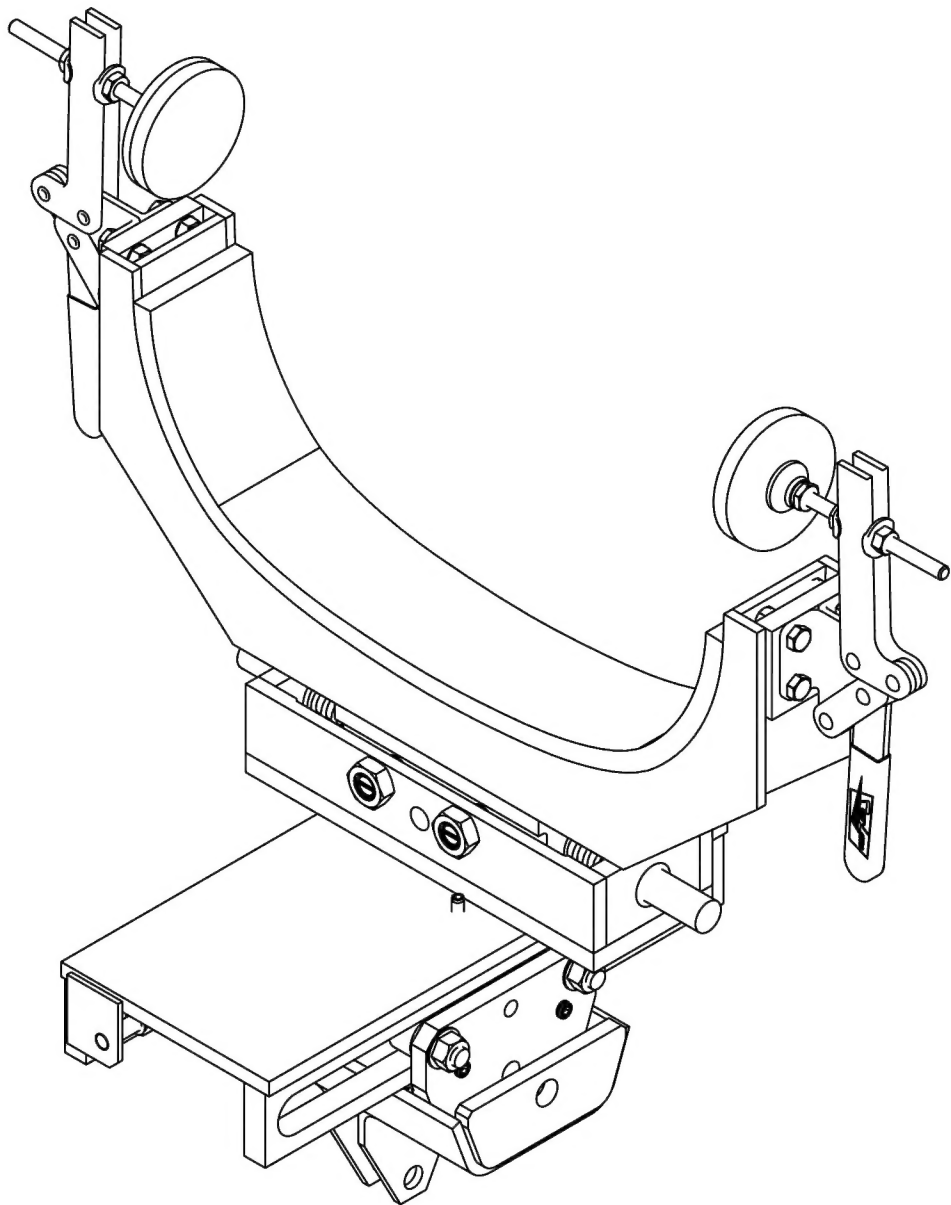


			
TITLE			
SUPPORT DOLLY, TAILBOOM			
DWG NO.			REV
RB T102012-15			1
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/√	
HEAT			
TREAT			
FINISH			
SPEC			
DRAWN BY:		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKS APPR:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
APPROVED:		BELL 212, 214B, 214ST, 412	
SCALE	1:4	DATE	3/13/2014
		SHEET 1 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-131	1	CRADLE WELDMENT			3
				2		-133		CRADLE	A36/1018/1020 HR		4
				1		-135		CRADLE FACE	A36/1018/1020 HR		5
				2		-137		CRADLE END PLATE	A36/1018/1020 HR		6
				1		-139		TOW END CRADLE, PIVOT	A36/1018/1020 HR		7
			X			-141	1	BOX WELDMENT			8
			1			-143		BOX BOTTOM	A36/1018/1020 HR		9
			2			-145		BOX FRONT	A36/1018/1020 HR		10
			2			-147		BOX END	A36/1018/1020 HR		11
			1			-149		STUD	A36/1018/1020 HR		12
		X				-151	1	SLIDE WELDMENT			13
		1				-153		SLIDE TOP	A36/1018/1020 HR		14
		1				-155		SLIDE SIDE	A36/1018/1020 HR		15
		1				-157		SLIDE SIDE-BOLTED	A36/1018/1020 HR		16
		1				-159		SLIDE SPRING ROD SUPPORT	A36/1018/1020 HR		17
						-161	1	SLIDE SPRING ROD SUPPORT, BOLTED	A36/1018/1020 HR		18
	X					-163	1	CUP WELDMENT			19
	1					-165		CUP	1018/1020 CR		20
	2					-167		CUP, END	A36/1018/1020 HR		21
	1					-169		CUP CENTER	A36/1018/1020 HR		22
	2					-171		CUP, MID	A36/1018/1020 HR		23
						-173	1	CRADLE ROD	4140 G&P		24
						-175	1	SPRING ROD	303 S.S.		25
						-177	1	ROD SUPPORT	A36/1018/1020 HR		26
						-179	1	FLANGE BEARING	BRONZE	Ø1-5/8 I.D. SYMCO #SF-5264-32 (MODIFIED)	27
						-181	2	PIVOT BRACKET	A36/1018/1020 HR		28
						-183	2	RUBBER PAD	RUBBER	20A-40A DUROMETER RATING	29
X						-185	2	REST WELDMENT			30
1						-187		REST WELDMENT PAD	A36/1018/1020 HR		31
1					B/O	-189		LEVELING STUD	STEEL	CARR LANE # CL-5-SLF-4	30
					B/O	-191	1	CRADLE PAD	17124	1/2 X 3 X 24	32
					B/O	-193	14	HEX HEAD CAP SCREW	STEEL	5/16-18 X 1 (MCMASTER-CARR #92865A583)	1
					B/O	-195	14	HEX NUT	STEEL	5/16-18 (MCMASTER-CARR #95462A030)	1
					B/O	-197	14	WASHER	STEEL	Ø5/16 (MCMASTER-CARR #95229A450)	1
					B/O	-199	4	SET SCREW	STEEL	3/8-16 X 5/8 (MCMASTER-CARR #94105A613)	1
					B/O	-201	4	HEX NUT	STEEL	7/16-20 (MCMASTER-CARR #95462A520)	1
					B/O	-203	8	WASHER	STEEL	Ø7/16 (MCMASTER-CARR #90126A032)	1
					B/O	-205	4	TRACK ROLLER	STEEL	Ø1 X 5/8 (MCMASTER-CARR #1460T17)	1
					B/O	-207	2	COMPRESSION SPRING	STEEL	Ø.092 X Ø3/4 O.D. X 5 (MCMASTER-CARR #9657K215)	1
					B/O	-209	2	SLOTTED SPRING PIN	STEEL	Ø1/4 X 3/4 (MCMASTER-CARR #90692A740)	1
					B/O	-211	1	SLOTTED HEX NUT	STEEL	1-1/4 -12 (MCMASTER-CARR #95030A360)	1
					B/O	-213	1	THRUST CAGE ASSEMBLY	STEEL	2-3/4 O.D. (MCMASTER-CARR #5909K43)	1
					B/O	-215	2	THRUST WASHER	STEEL	Ø2-3/4 O.D. (MCMASTER-CARR #5909K56)	1
					B/O	-217	4	HEX NUT	STEEL	5/8-11 (MCMASTER-CARR #94846A533)	1
					B/O	-219	4	BALL-NOSE SPRING PLUNGER	STEEL	5/8-11 X .984 (MCMASTER-CARR #3408A124)	1
					B/O	-221	2	COMPRESSION SPRING	STEEL	Ø.105 X Ø.97 O.D. X 3-1/2 (MCMASTER-CARR #9657K455)	1
					B/O	-223	1	SLOTTED SPRING PIN	STEEL	Ø1/4 X 2 (MCMASTER-CARR #90692A749)	1
					B/O	-225	2	FLANGE BEARING	BRONZE	SYMCO #SF-2432-10	1
					B/O	-227	2	TOGGLE CLAMP	STEEL	CARR-LANE #CL-351-TC	1
					B/O	-229	4	FLANGED WASHERS	TEMPERED SPRING STEEL	CARR-LANE #CL-51610-TW	1
					B/O	-231	1	COTTER PIN	STEEL	Ø3/16 X 3 (MCMASTER-CARR #98338A290)	1
					B/O	-233	5	HEX NUT	STEEL	3/8-24 MCMASTER-CARR #95462A515	1
-185 ASSY	-163 ASSY	-151 ASSY	-141 ASSY	-131 ASSY							



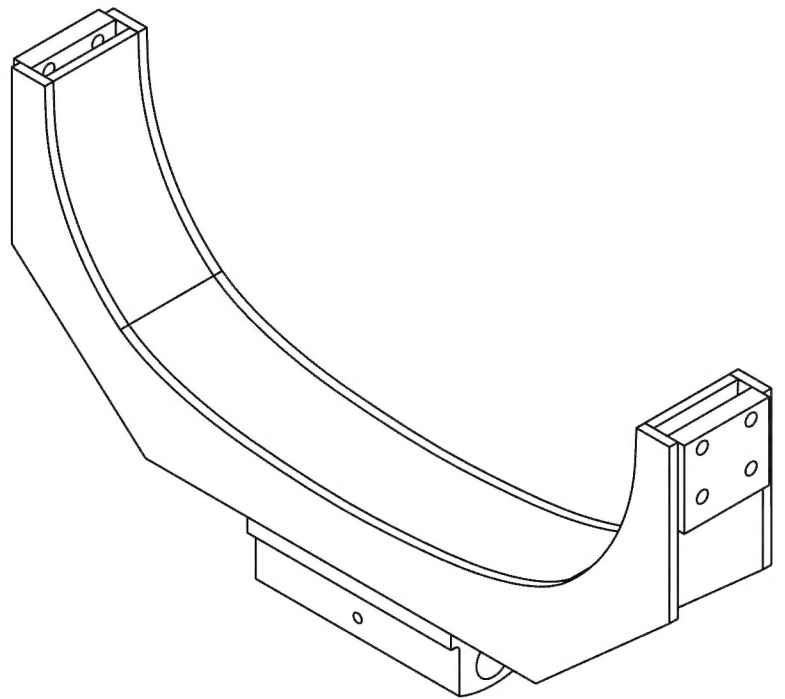
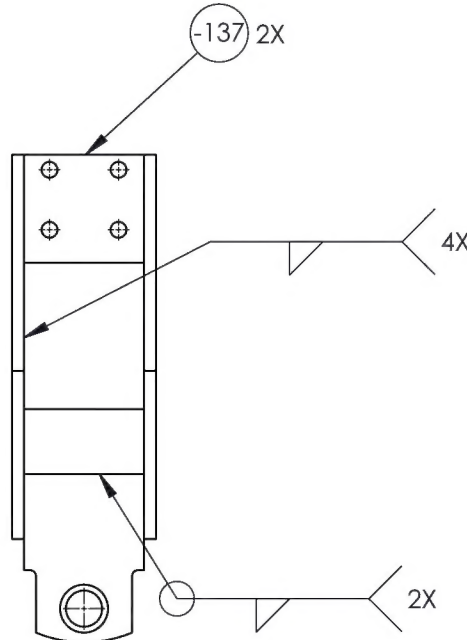
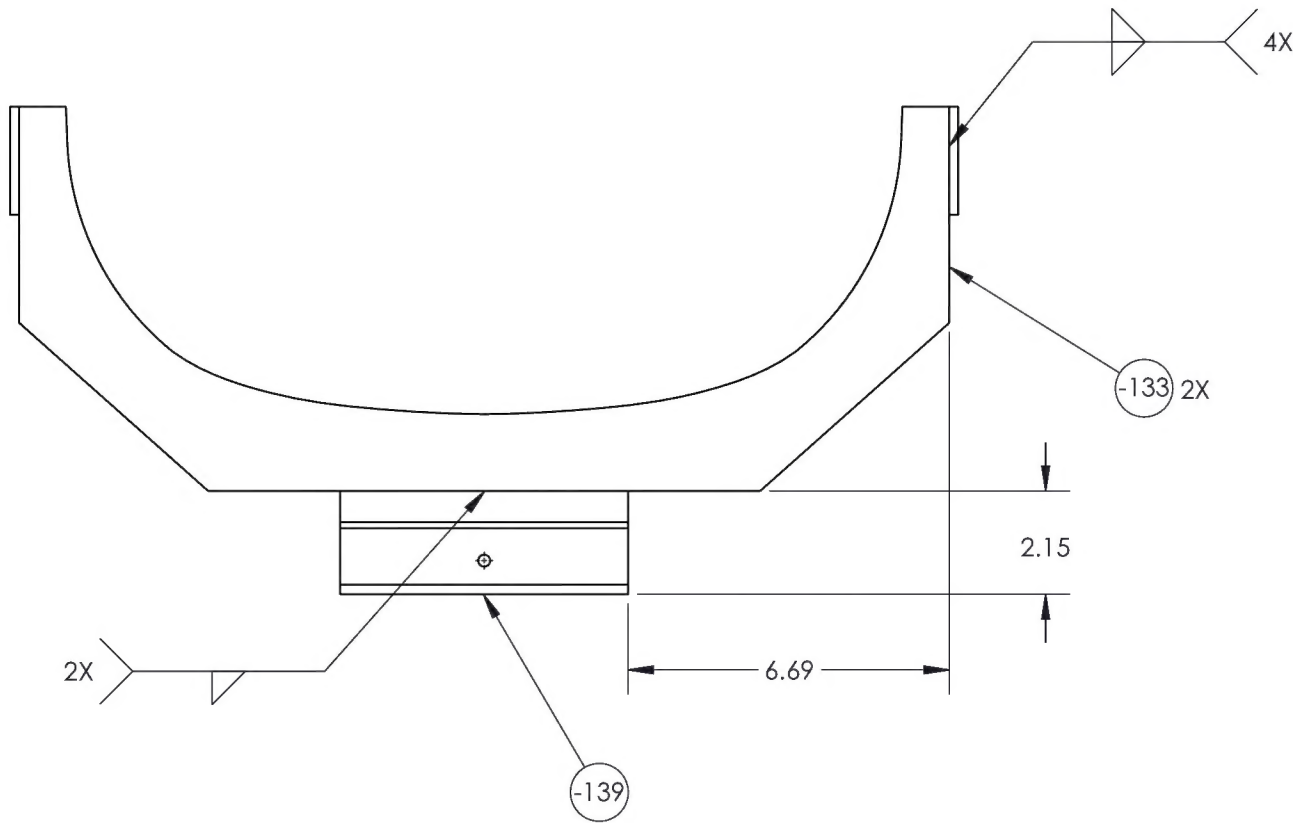
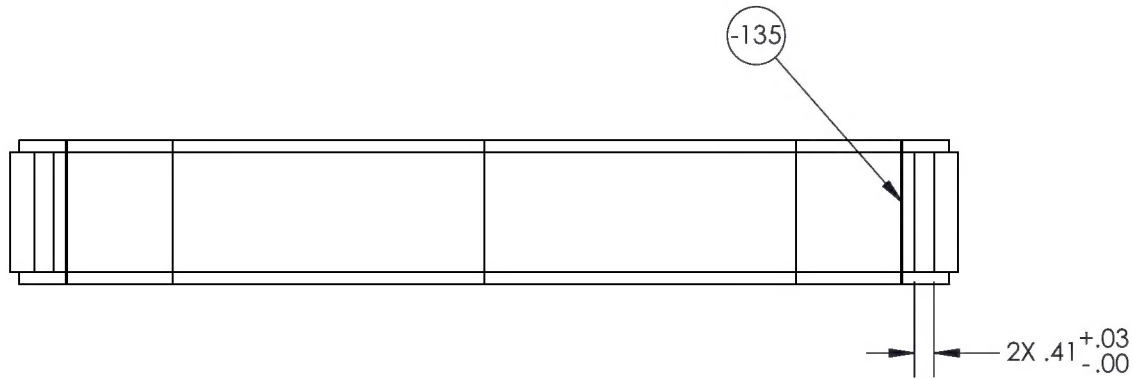
(15)

TOW SIDE LIFT

DART AEROSPACE			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-15			REV 1
MAT'L HEAT TREAT FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ±.5° .X ± .1 SURFACES = 125/✓	
DRAWN BY:	GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	LINDSAY	USED ON MODEL	
APPROVED:	GILBERT	BELL 212, 214B, 214ST, 412	
SCALE	1:4	DATE	3/13/2014
		SHEET 2 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
APPROVED				



-131

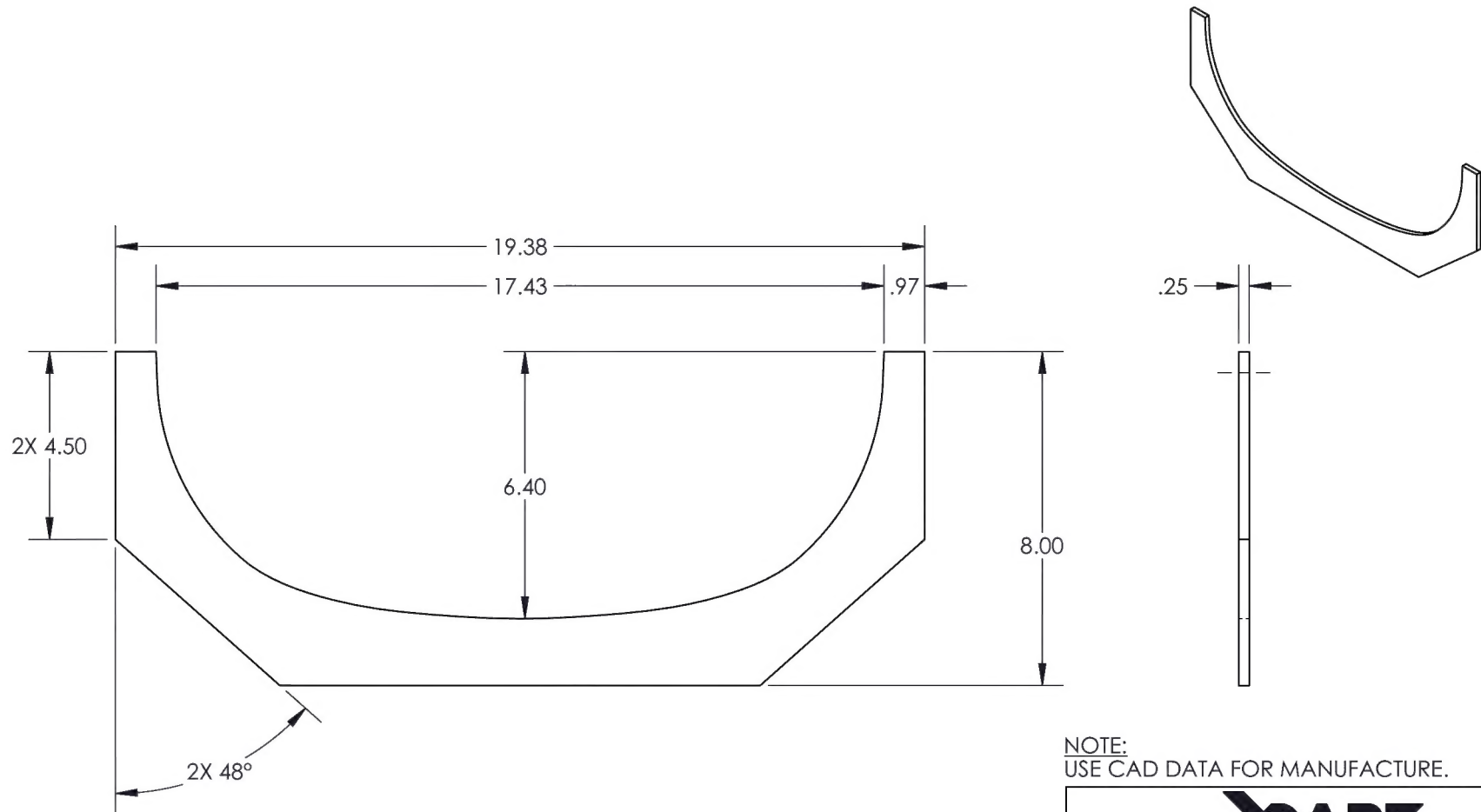
CRADLE WELDMENT

NOTE:
NO POWDER COAT IN HOLES.

DART AEROSPACE			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-131			REV 1
MAT'L	UNLESS OTHERWISE SPECIFIED		
HEAT TREAT	DIMENSIONS ARE IN INCHES		
FINISH	.XXX ± .010 FRACTIONS ± 1/8		
SPEC	.XX ± .03 ANGLES ± 1°		
FED #13538	.X ± .1 SURFACES = 125		
DRAWN BY:	GILBERT	1. BREAK ALL SHARP EDGES	
CHECKED:	CLOUGH	.015 x 45° OR .015R	
OPPS APPR:	ANDERSON	2. DIMENSIONAL LIMITS APPLY	
QA APPR:	LINDSAY	AFTER PLATING	
APPROVED:	GILBERT	3. INTERPRET DIM AND TOL PER	
SCALE	1:4	ASME Y14.5M-2009	
DATE	3/13/2014	USED ON MODEL	
		BELL 212, 214B, 214ST, 412	
		SHEET 3 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



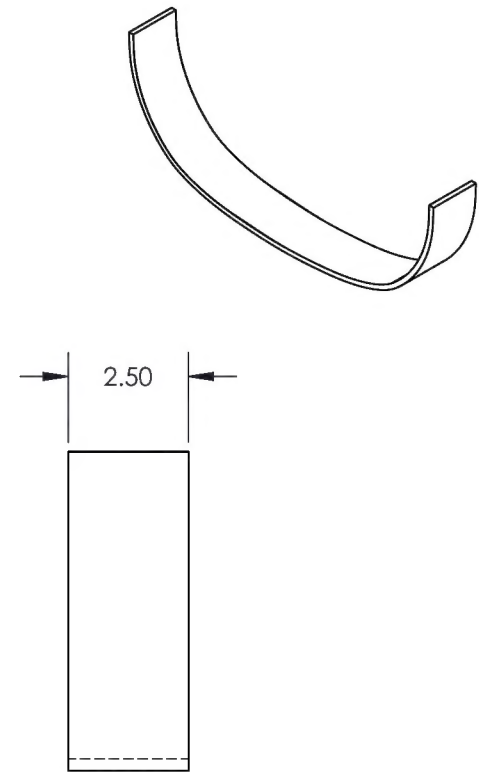
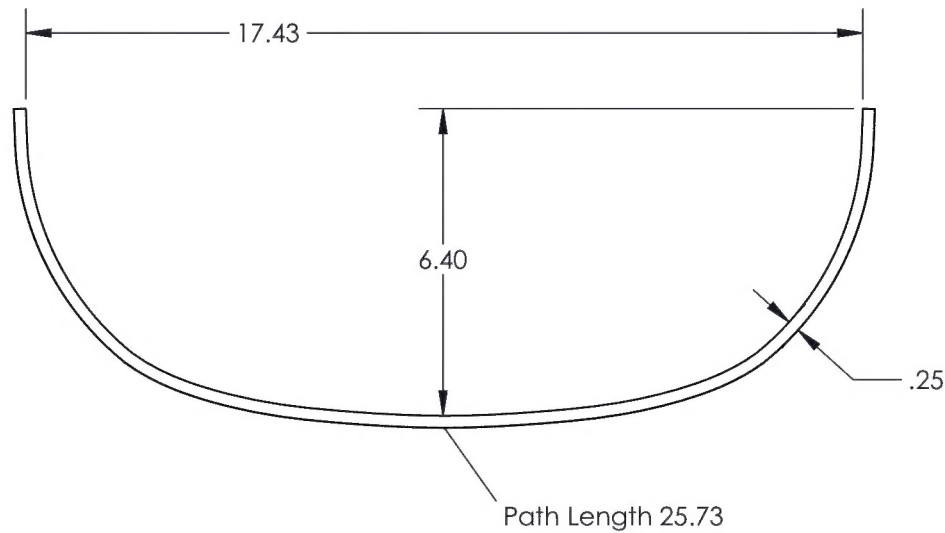
NOTE:
USE CAD DATA FOR MANUFACTURE.

(-133)
CRADLE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-133	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -131 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:4	DATE 3/13/2014
	SHEET 4 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



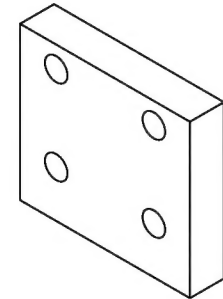
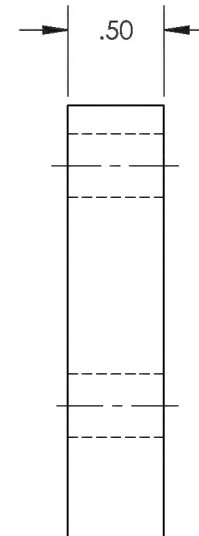
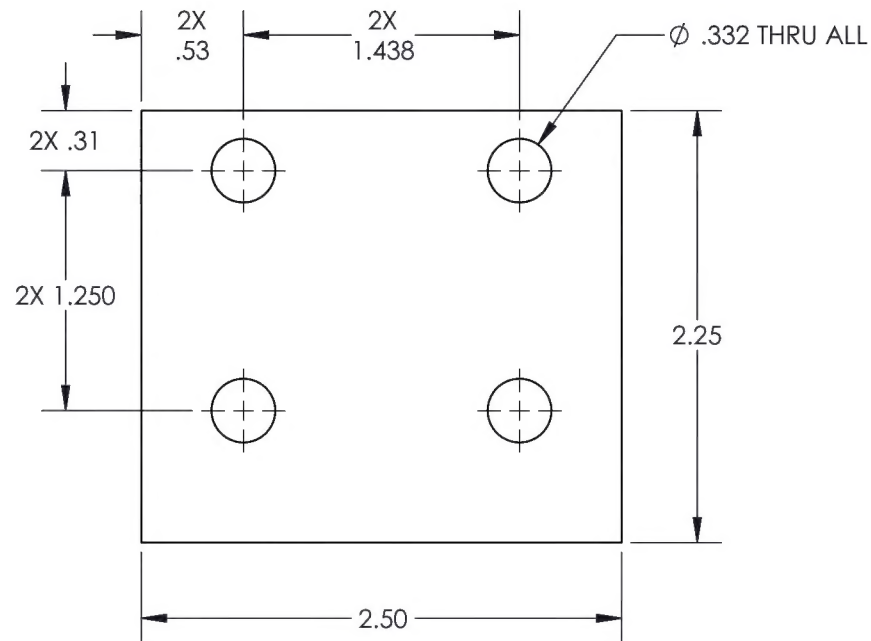
NOTE:
FIT TO WELDMENT.

(-135)
CRADLE FACE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-135	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -131 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:4	DATE 3/13/2014
	SHEET 5 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



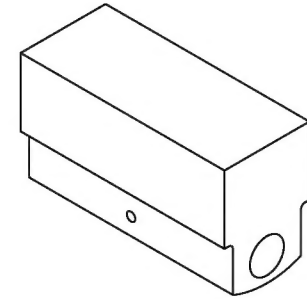
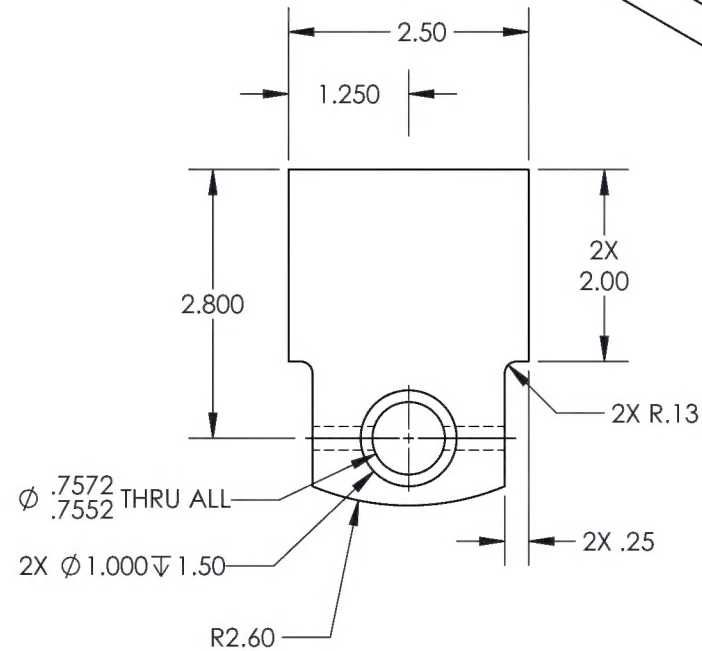
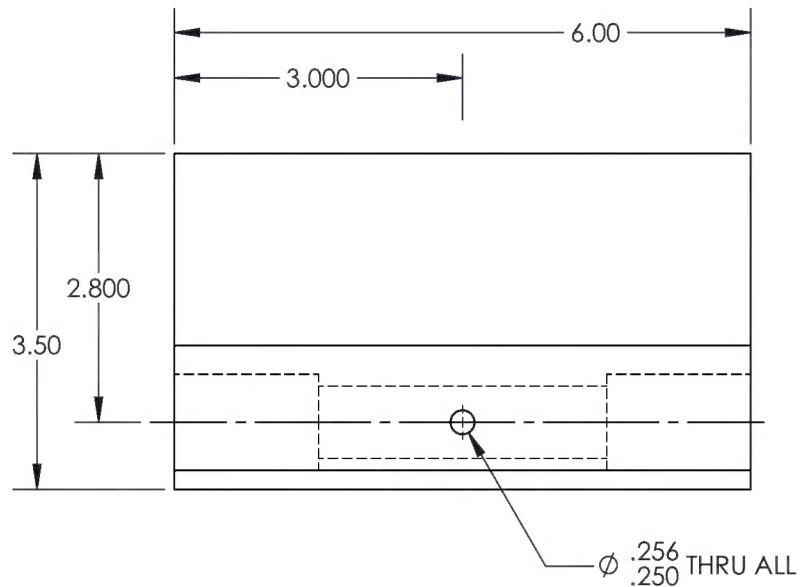
(-137)

CRADLE END PLATE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-137	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -131 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 6 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



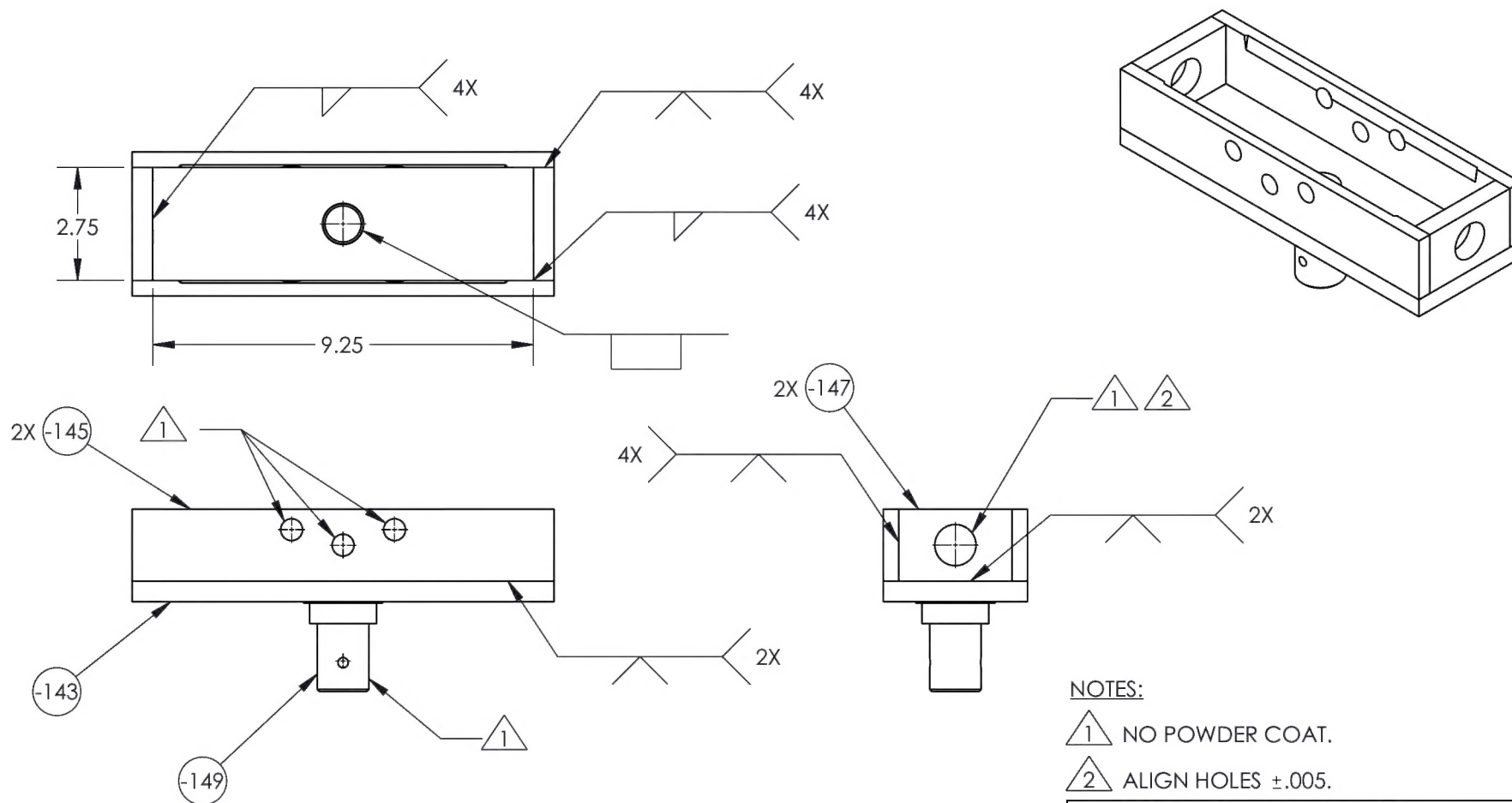
-139

TOW END CRADLE, PIVOT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-139	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -131 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 7 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTES:

1 NO POWDER COAT.

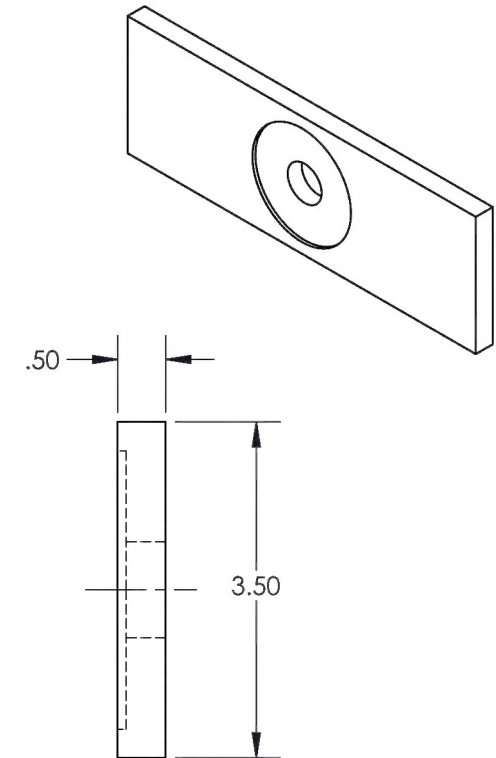
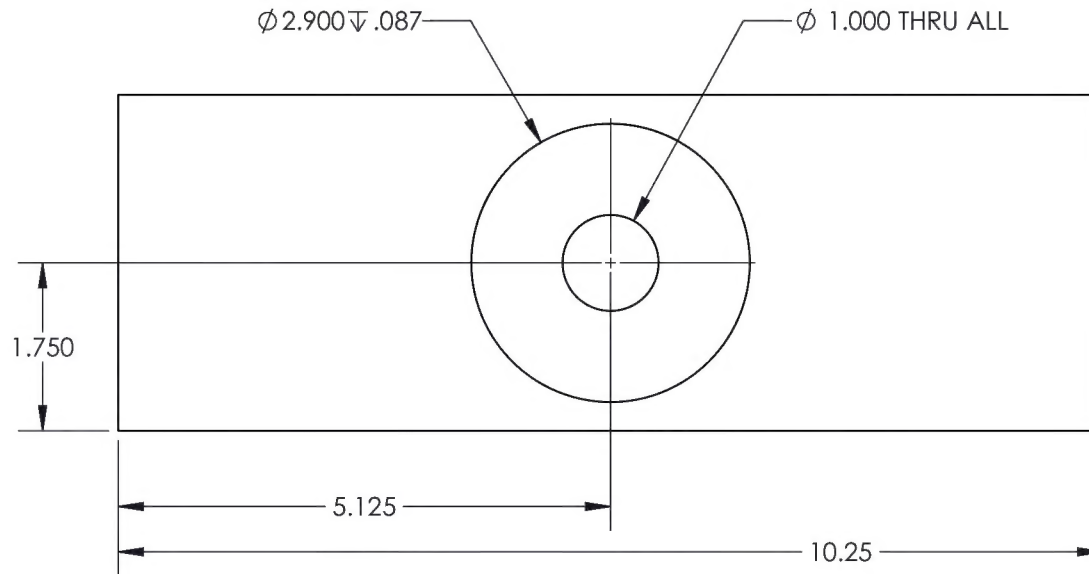
2 ALIGN HOLES ±.005.

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-141	REV 1
MAT'L REAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014
SHEET 8 OF 32	

-141
BOX WELDMENT

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



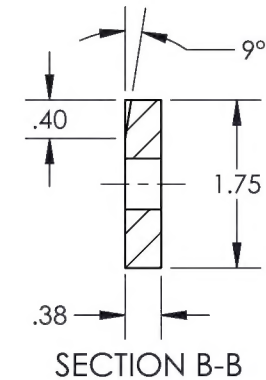
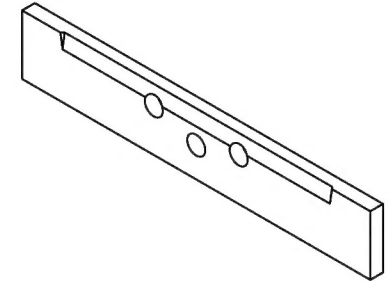
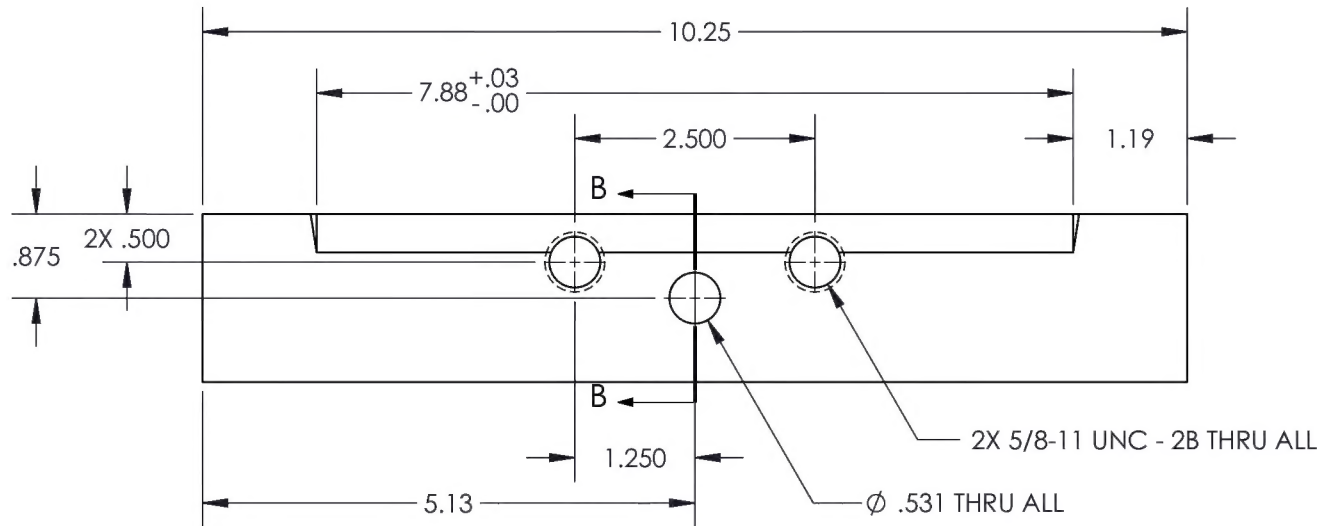
-143

BOX BOTTOM

TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-143	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX \pm .010 FRACTIONS \pm 1/8
SPEC	.XX \pm .03 ANGLES \pm 1°
DRAWN BY: GILBERT	.X \pm .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 9 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

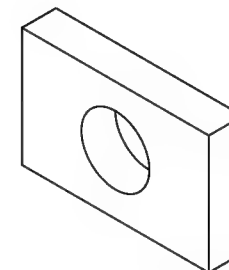
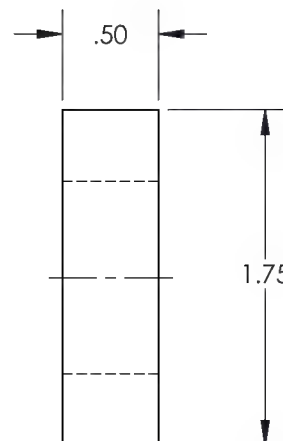
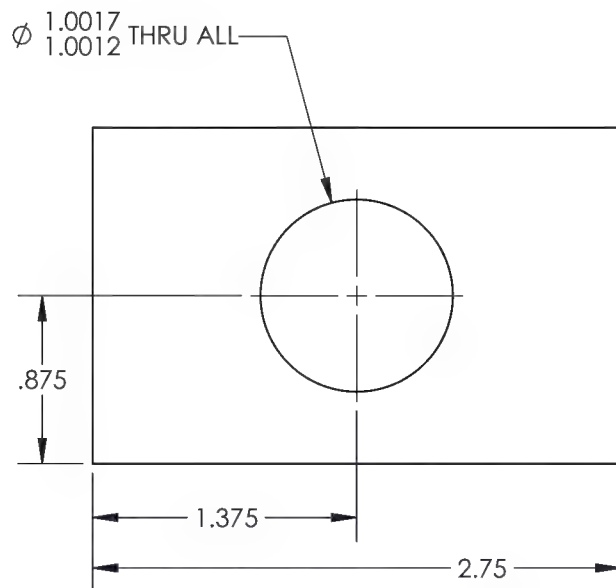


(-145)
BOX FRONT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-145	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 10 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

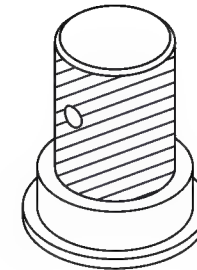
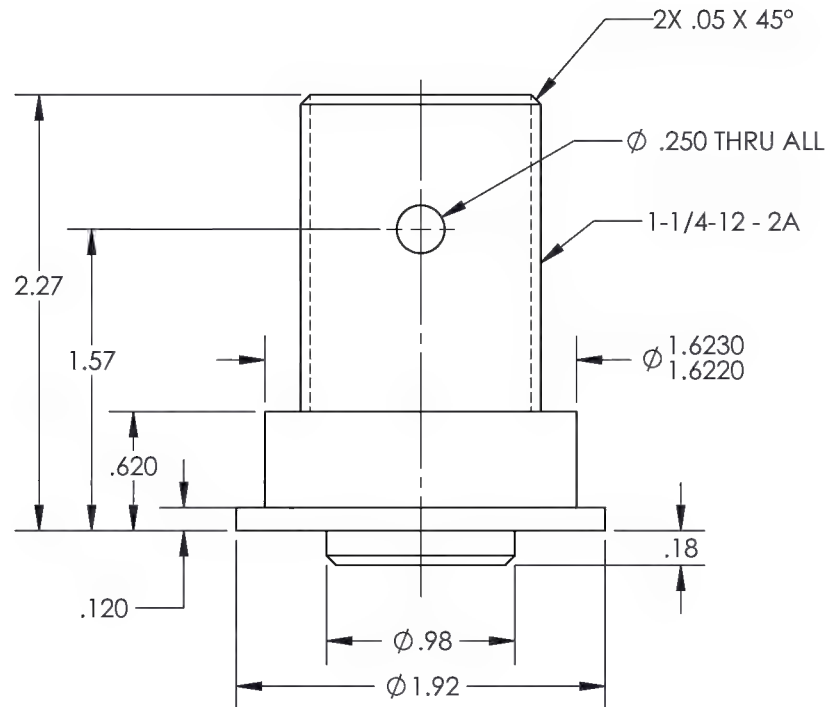


-147
 BOX END

TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-147	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC	.XX \pm .01 ANGLES \pm .5°
DRAWN BY: GILBERT	.X \pm .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
SHEET 11 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



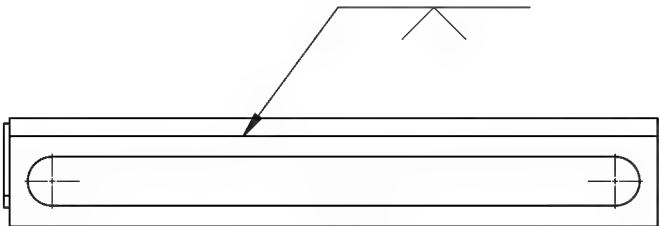
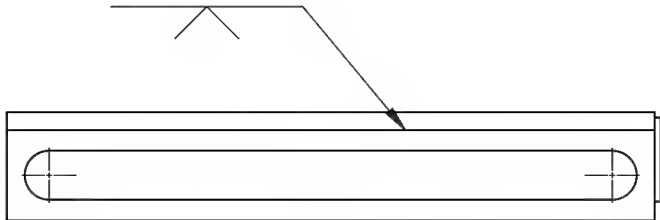
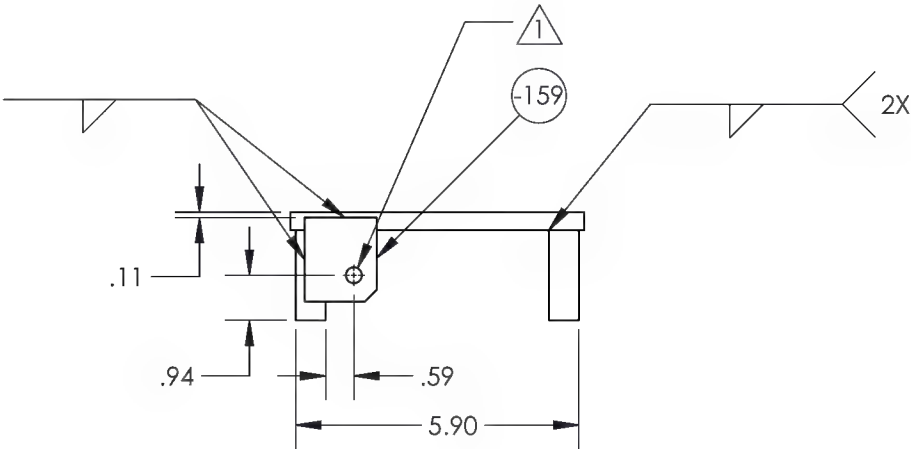
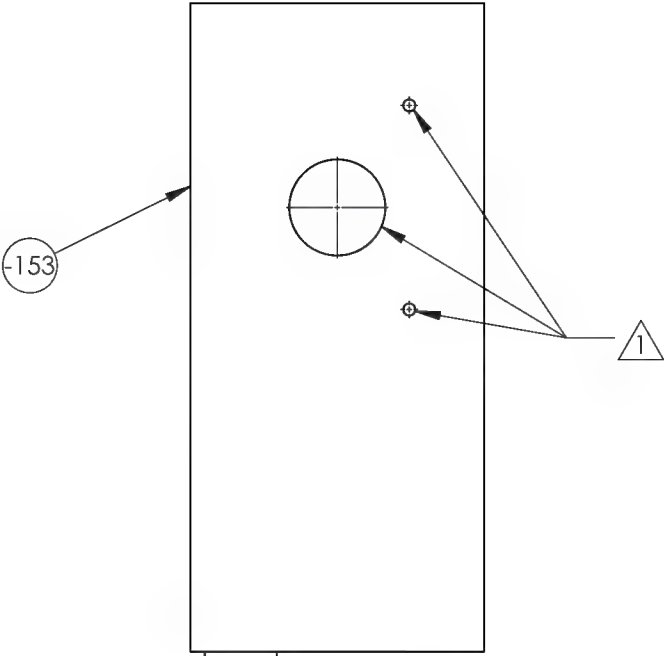
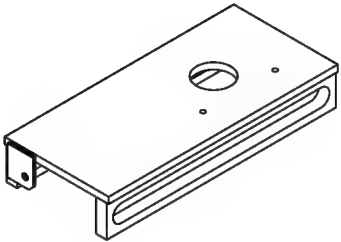
-149

STUD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-149	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -141 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 12 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.


REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTE:
1 NO POWDER COAT IN HOLES.

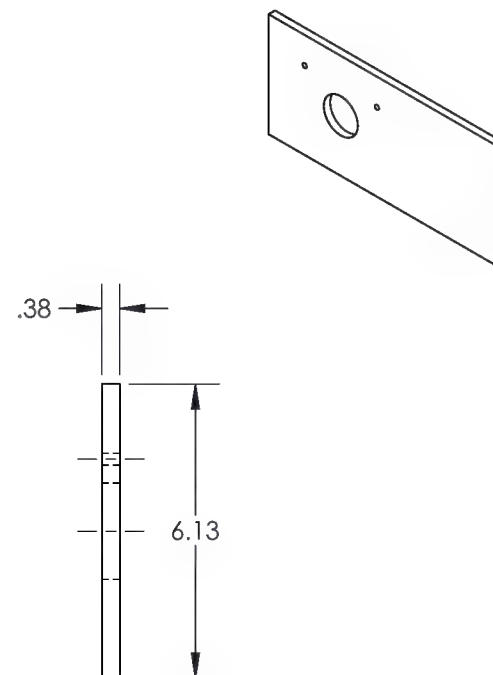
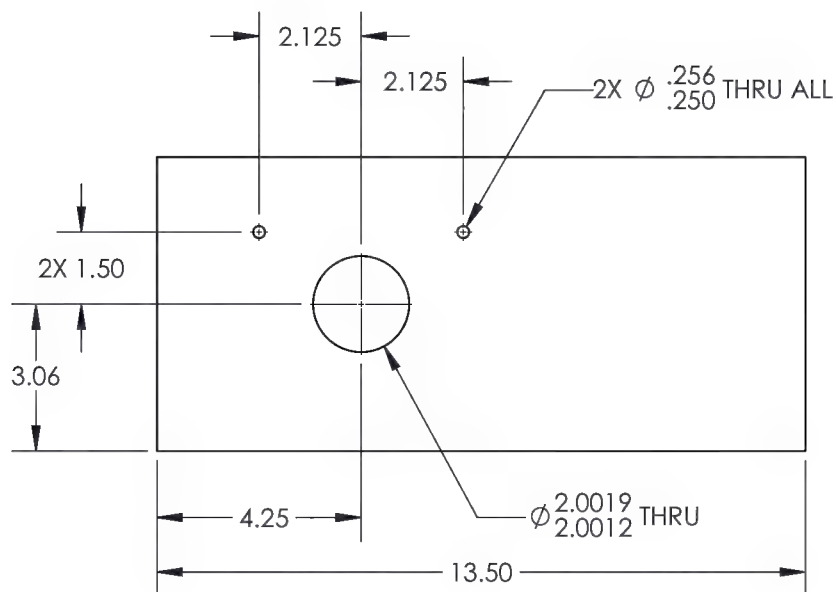
-151

SLIDE WELDMENT

			
TITLE SUPPORT DOLLY, TAILBOOM			
DWG NO. RB T102012-151			REV 1
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX \pm .010 FRACTIONS \pm 1/8	
FINISH POWDER COAT YELLOW		.XX \pm .03 ANGLES \pm 1°	
SPEC FED #13538		.X \pm .1 SURFACES = 125 ✓	
DRAWN BY: GILBERT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		BELL 212, 214B, 214ST, 412	
SCALE 1:4	DATE 3/13/2014	SHEET 13 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



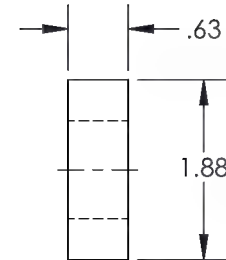
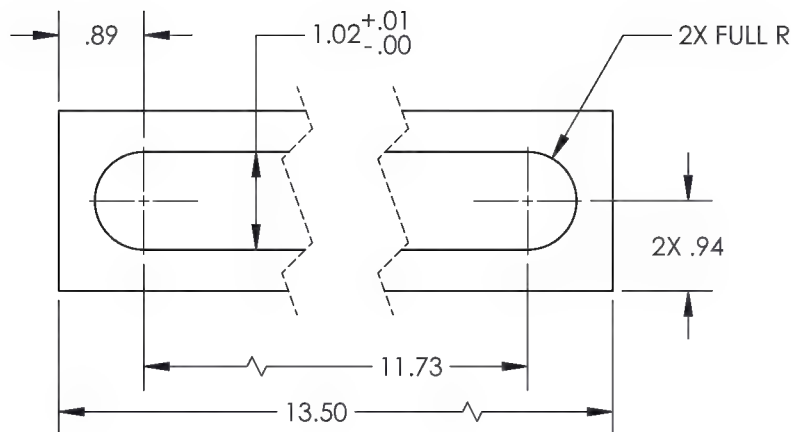
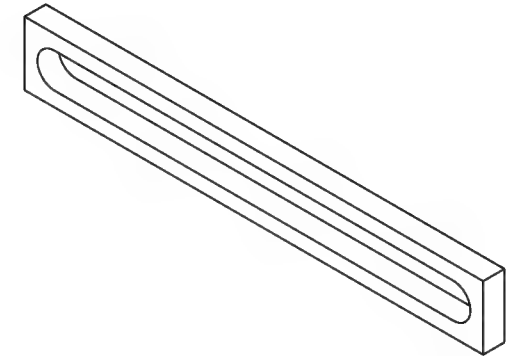
-153

SLIDE TOP

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-153	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -151 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:4	DATE 3/13/2014
	SHEET 14 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



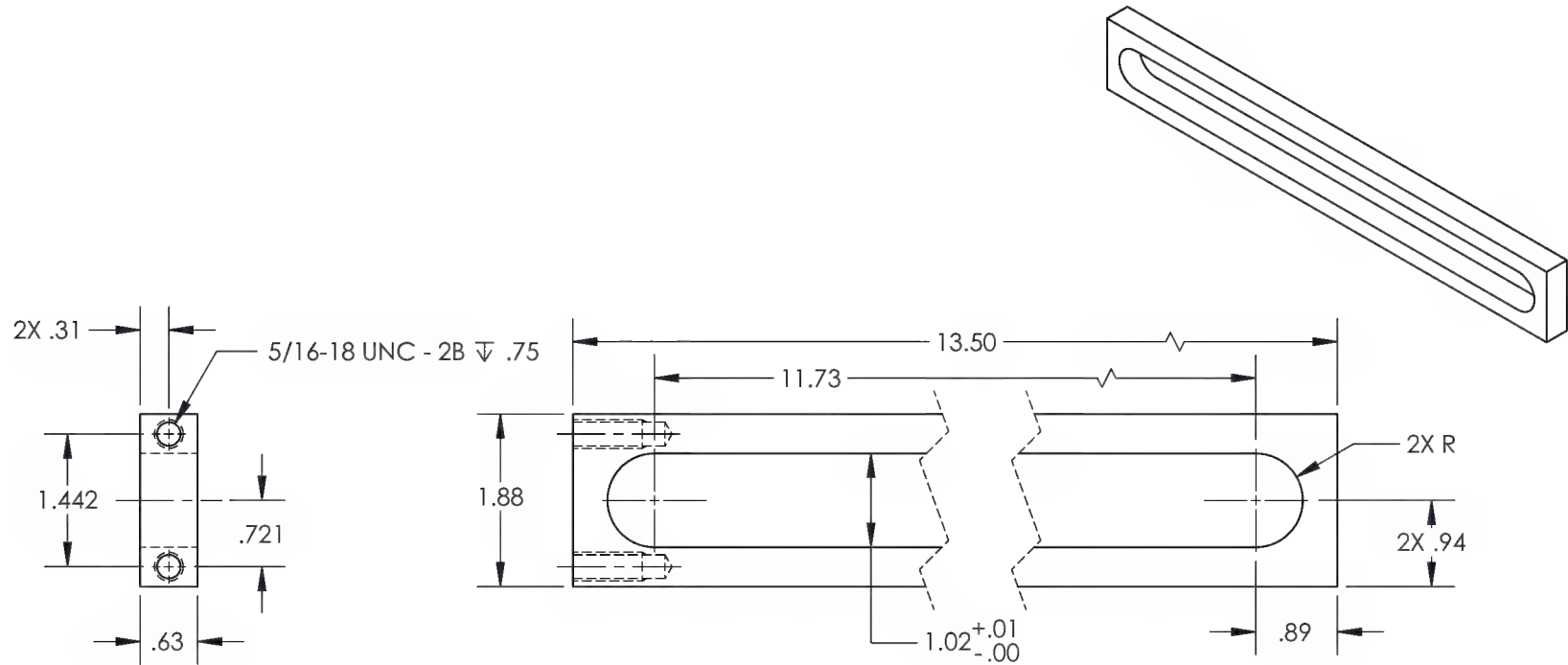
-155

SLIDE SIDE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-155	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -151 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -151 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 3/13/2014
SHEET 15 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



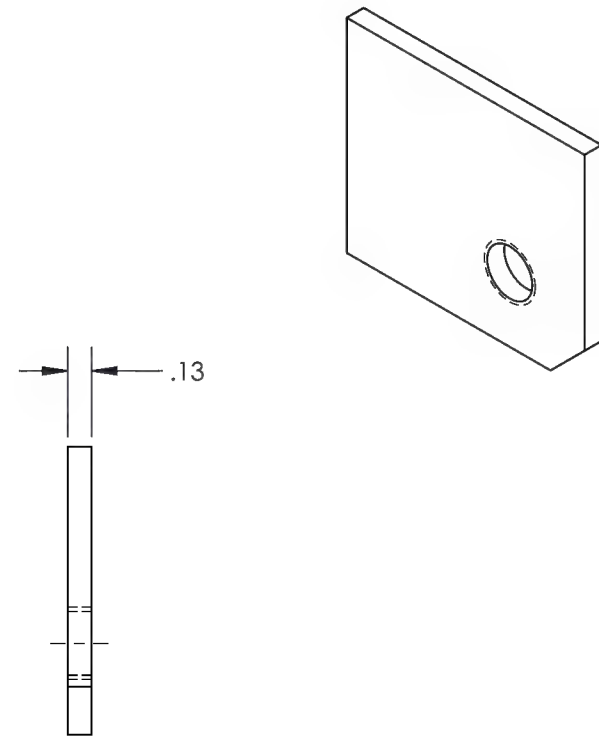
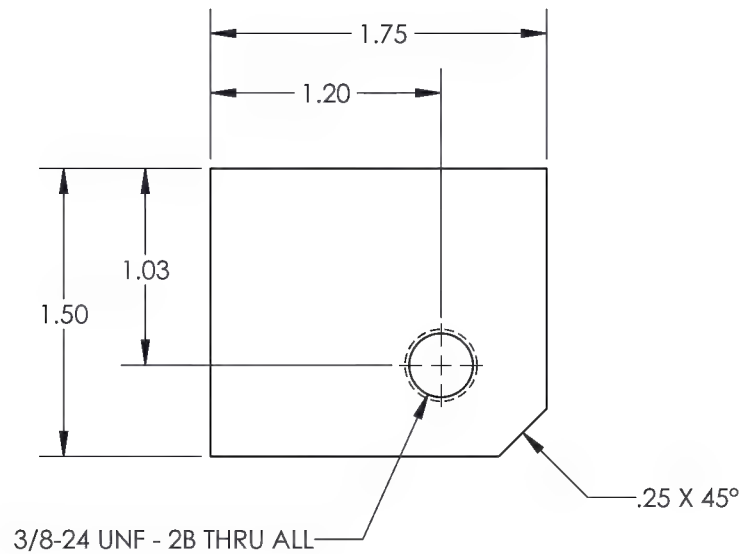
-157

SLIDE SIDE-BOLTED

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-157	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -151 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 16 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



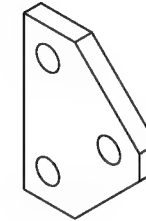
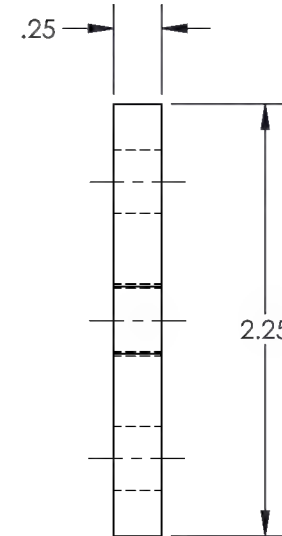
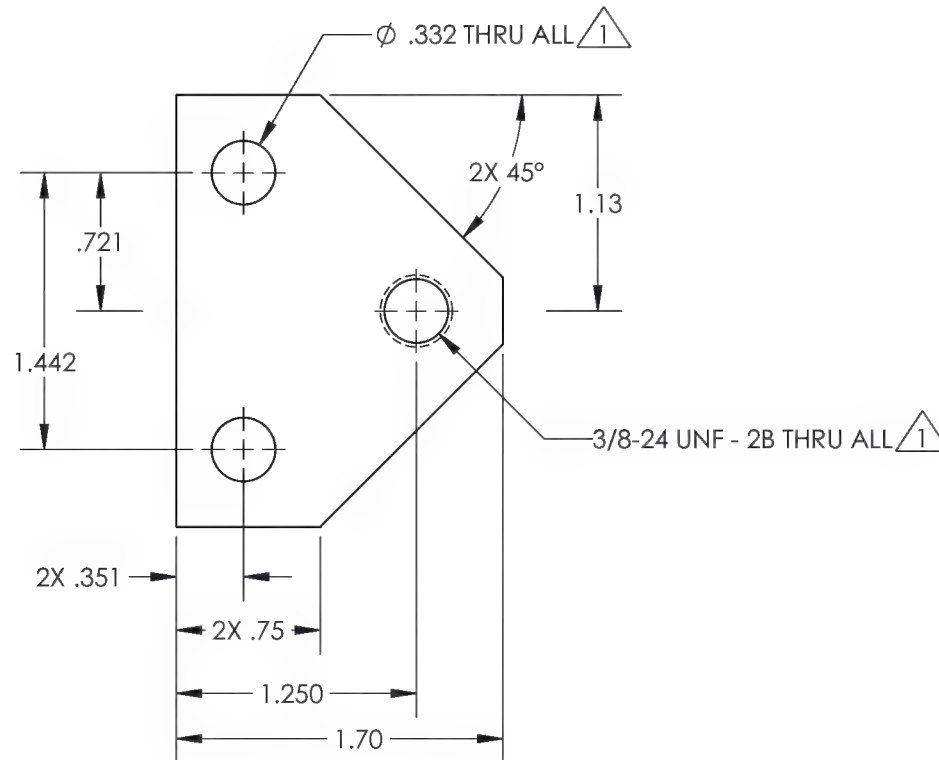
-159

SLIDE SPRING ROD SUPPORT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-159	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -151 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -151 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:1	DATE 3/13/2014
SHEET 17 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTE:

1 NO POWDER COAT IN HOLES.

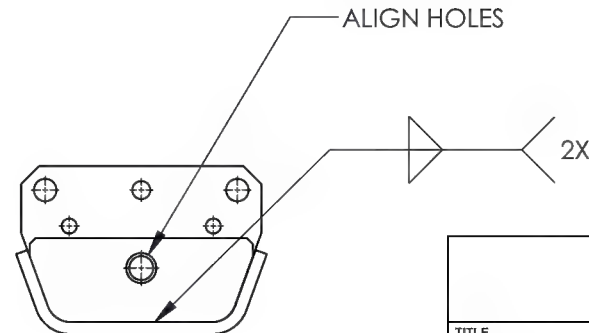
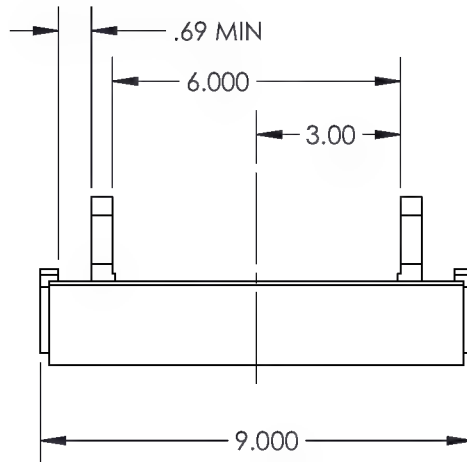
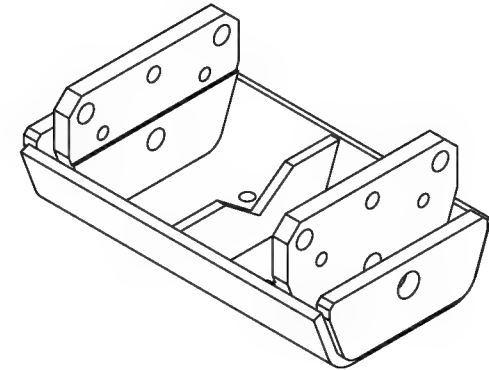
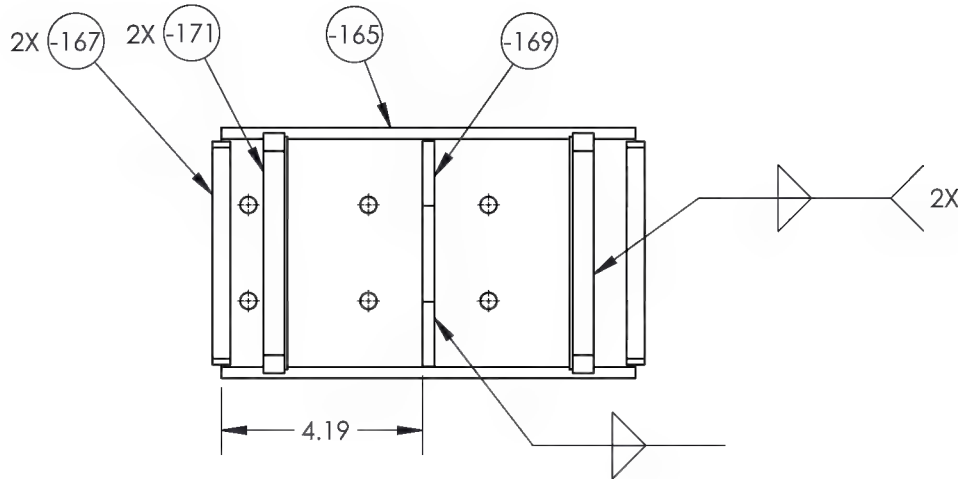
-161

SLIDE SPRING ROD SUPPORT, BOLTED

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-161	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .03 ANGLES ± 1°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 18 OF 32	BELL 212, 214B, 214ST, 412

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

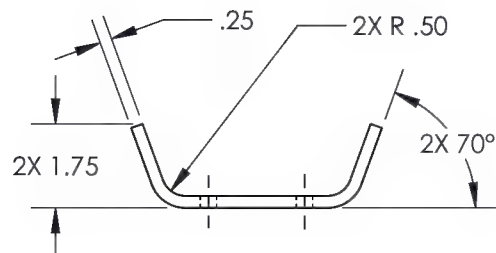
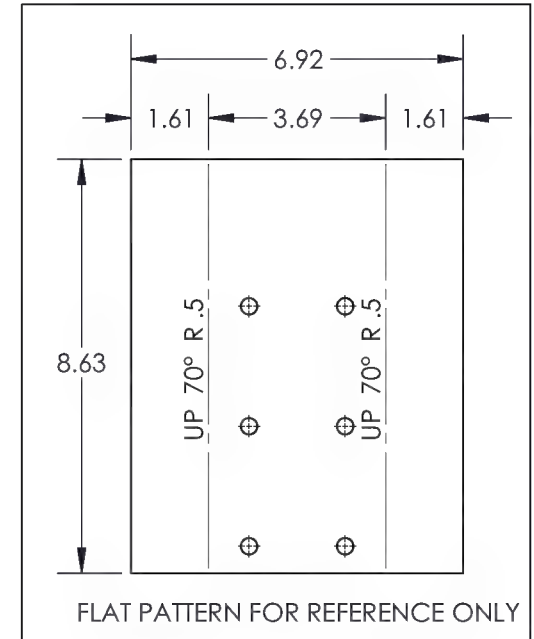
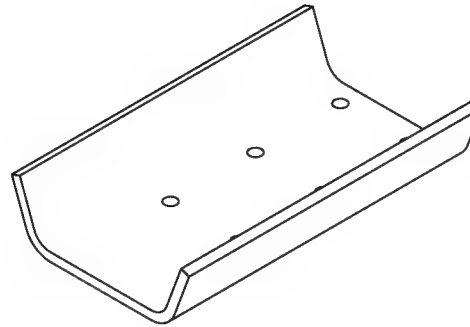
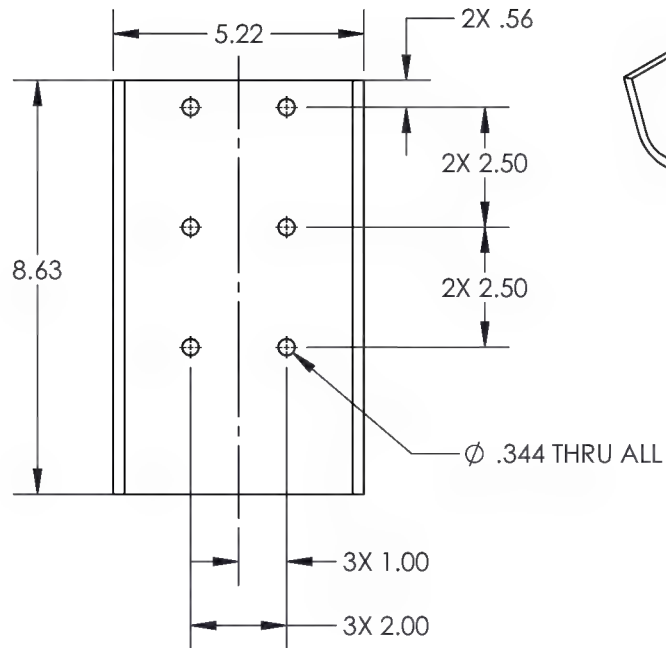


-163
CUP WELDMENT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-163	REV 1
MAT'L 6061-T6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
FINISH POWDER COAT YELLOW	.XX ± .03 ANGLES ± 1°
SPEC FED #13538	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:4	DATE 3/13/2014
SHEET 19 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

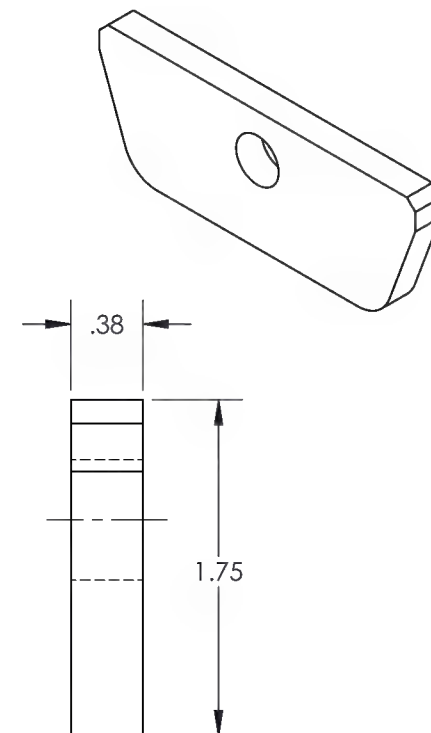
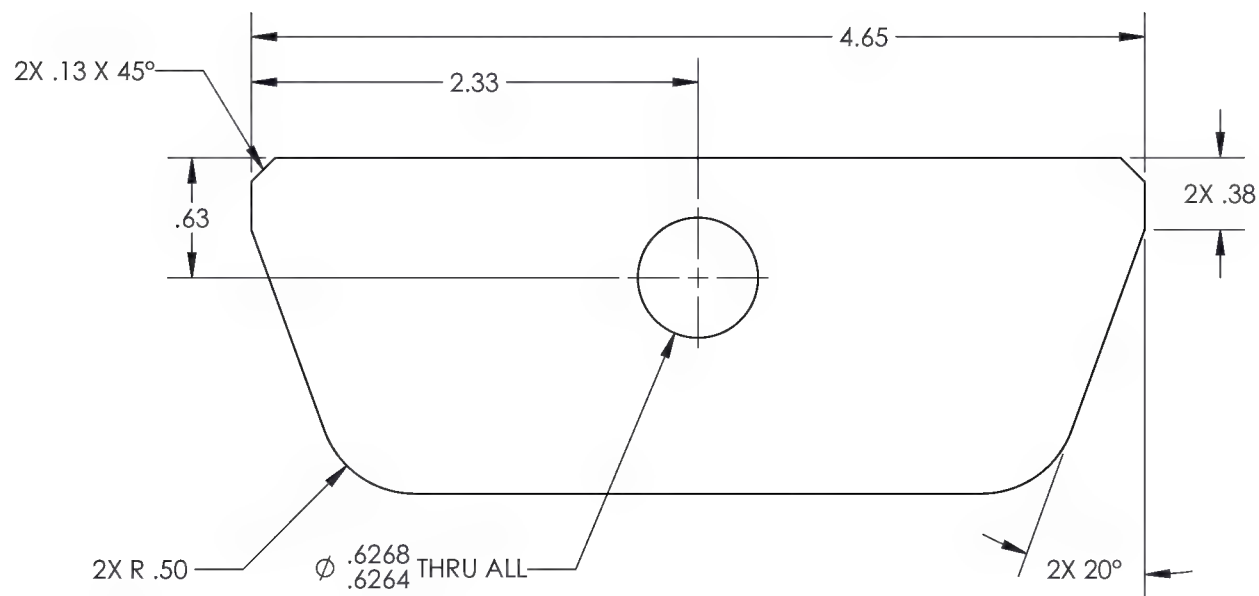


-165
CUP

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-165	REV 1
MAT'L 1018/1020 CR HEAT TREAT FINISH SEE -163 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .010 FRACTIONS \pm 1/8 .XX \pm .03 ANGLES \pm 1° .X \pm .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	USED ON MODEL
CHECKED: CLOUGH	BELL 212, 214B, 214ST, 412
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:4	DATE 3/13/2014
SHEET 20 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

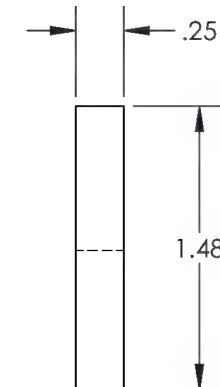
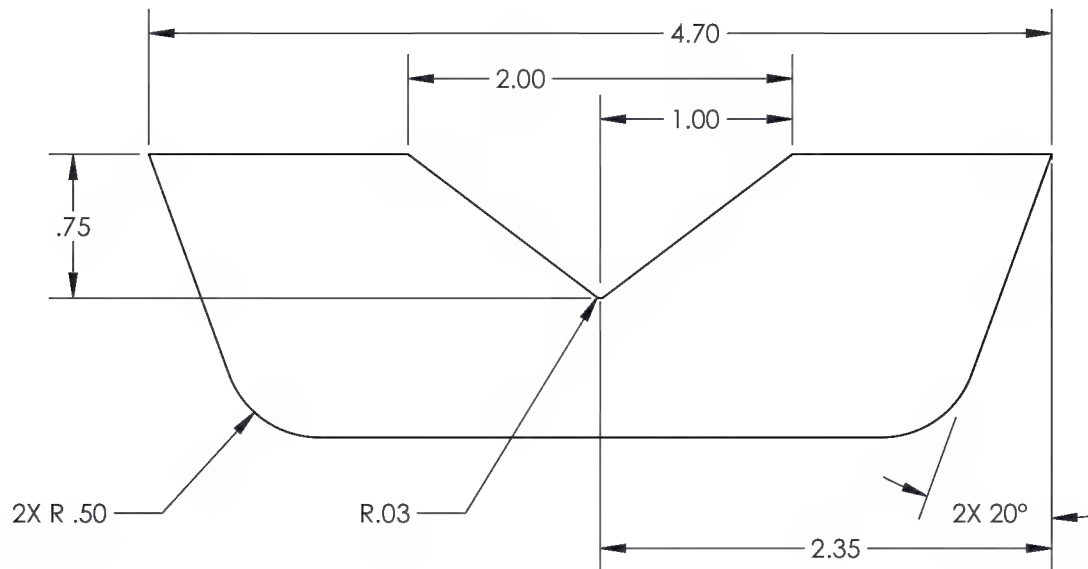
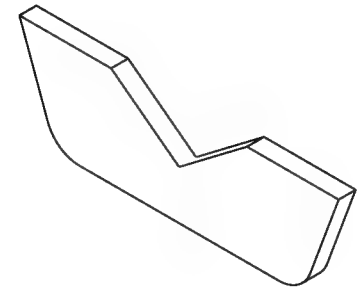


(-167)
CUP, END

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-167	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -163 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 21 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



-169

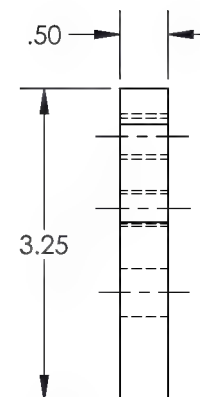
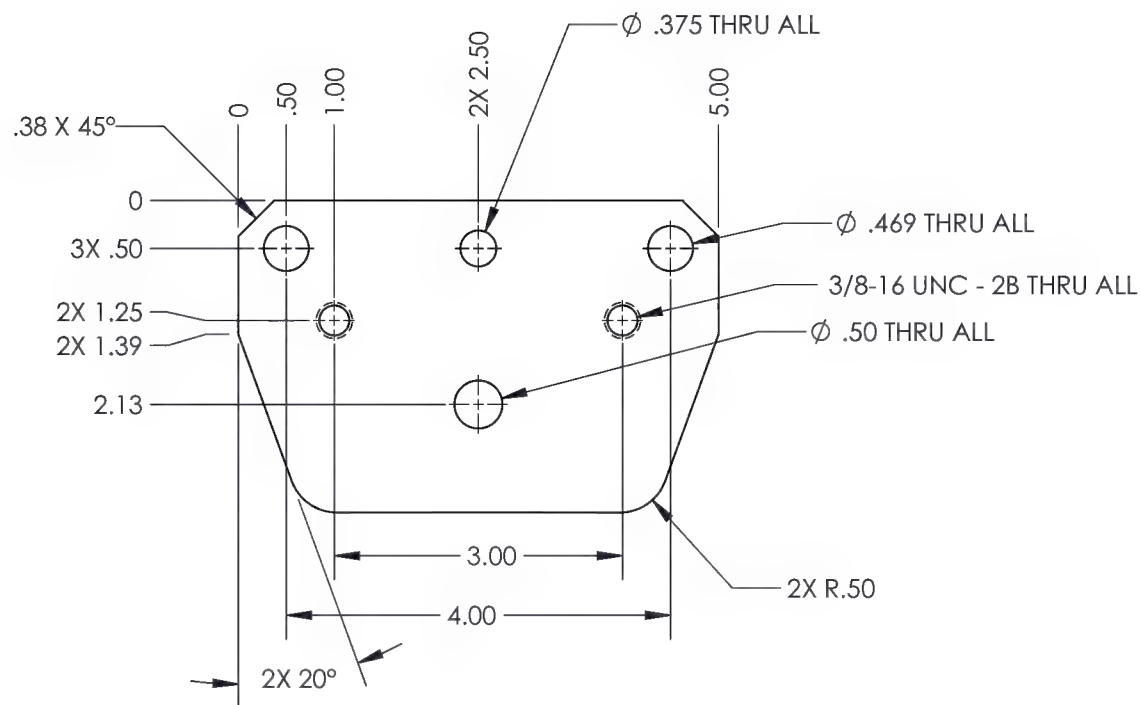
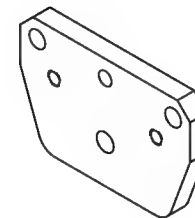
CUP CENTER



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-169	
REV		1	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -163 WELDMENT		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: GILBERT		.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/13/2014		USED ON MODEL	
SHEET 22 OF 32		BELL 212, 214B, 214ST, 412	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

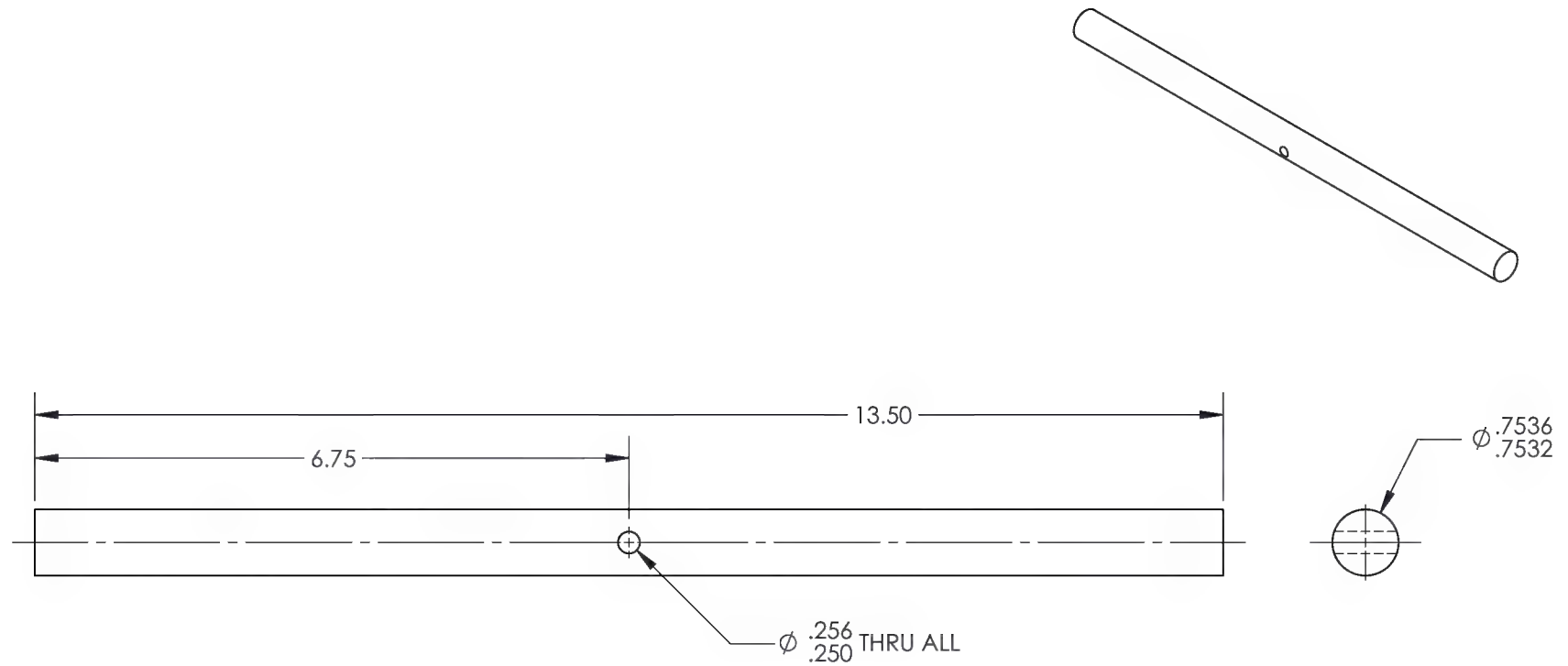


(-171)
CUP, MID

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-171	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -163 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -163 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 3/13/2014
SHEET 23 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

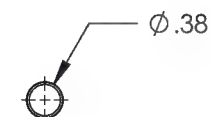
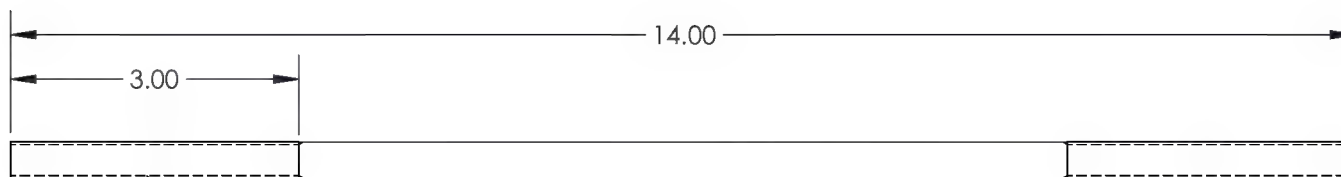
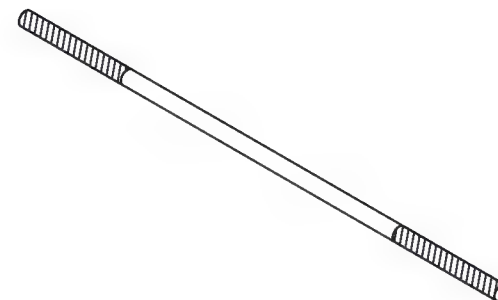
REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-173	REV 1
MAT'L 4140 G&P	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX \pm .005 FRACTIONS \pm 1/8
SPEC ASTM B633 TYPE I SC 2	.XX \pm .01 ANGLES \pm 5°
DRAWN BY: GILBERT	.X \pm .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 3/13/2014	BELL 212, 214B, 214ST, 412
SHEET 24 OF 32	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



2X 3/8-24 - 2A

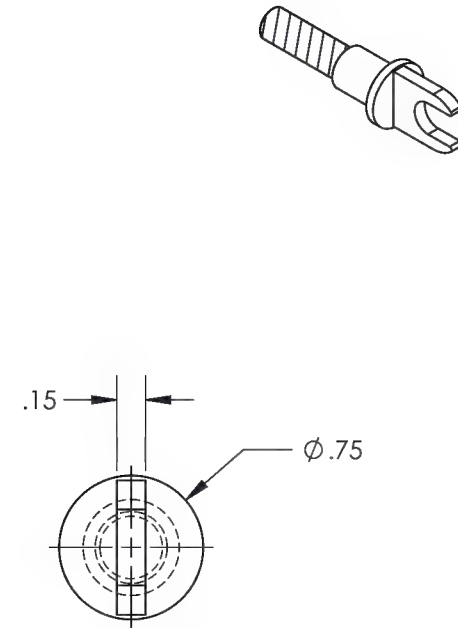
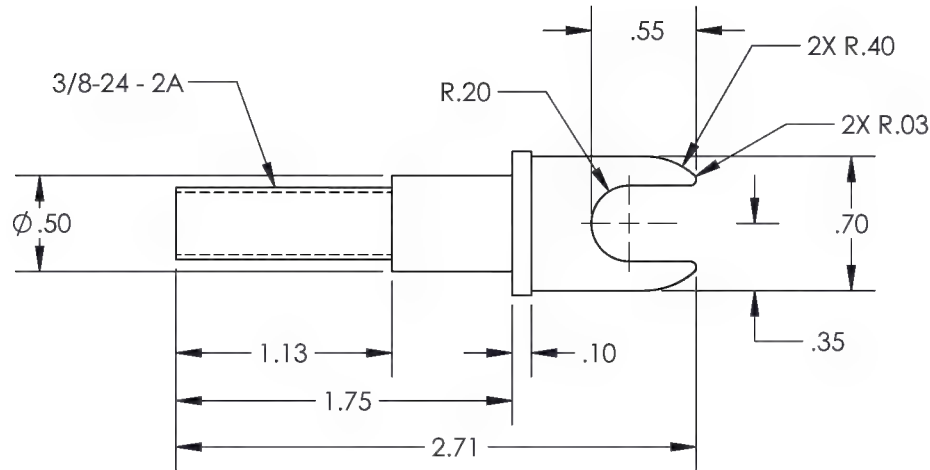
-175

SPRING ROD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-175	REV 1
MAT'L 303 S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 25 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



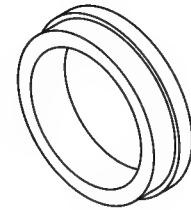
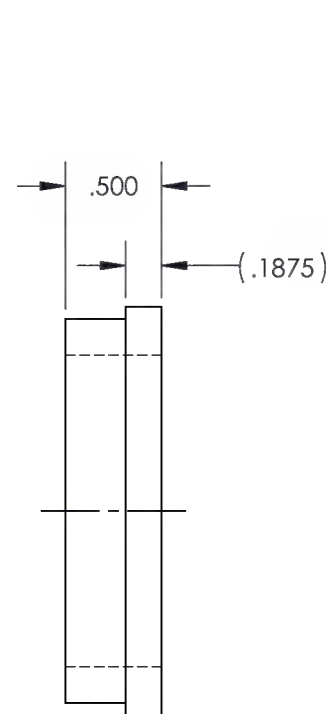
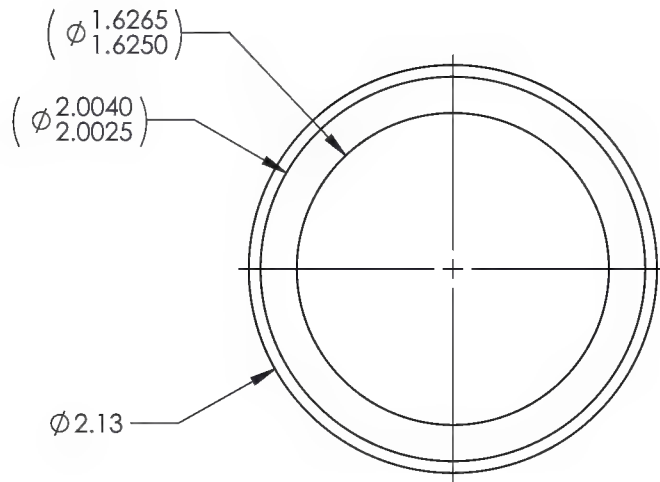
(-177)

ROD SUPPORT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-177	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125°
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 26 OF 32	BELL 212, 214B, 214ST, 412

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



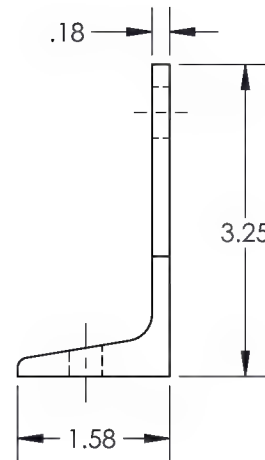
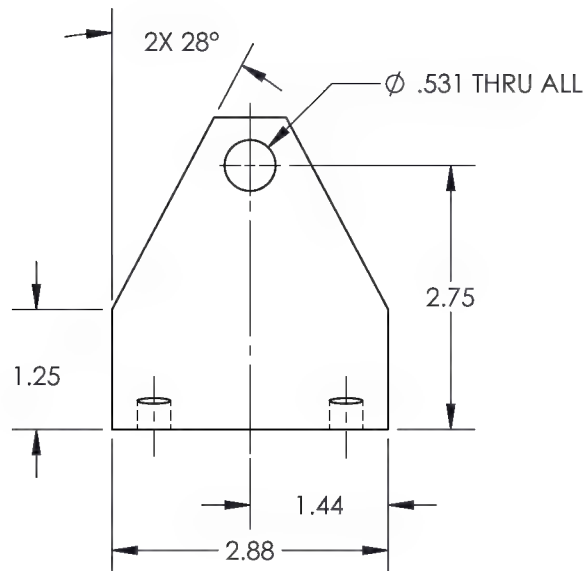
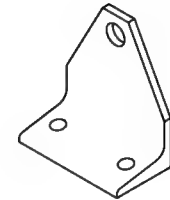
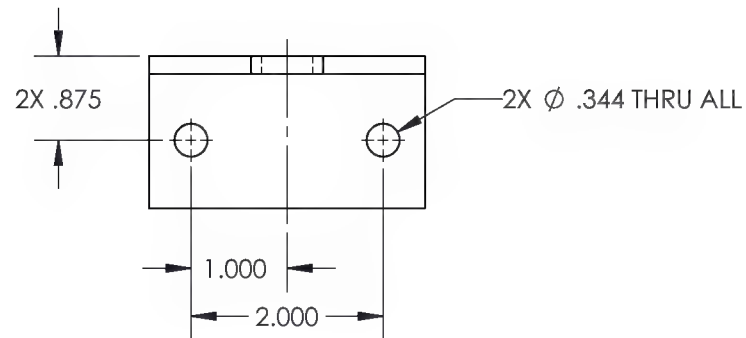
(-179)

FLANGE BEARING

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-179	REV 1
MAT'L BRONZE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 27 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



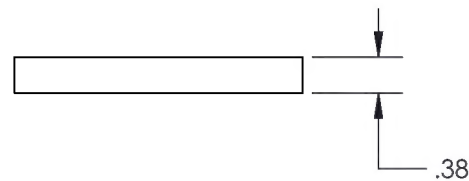
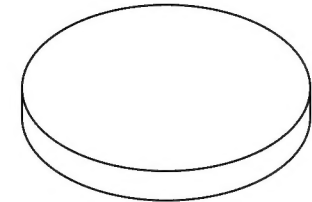
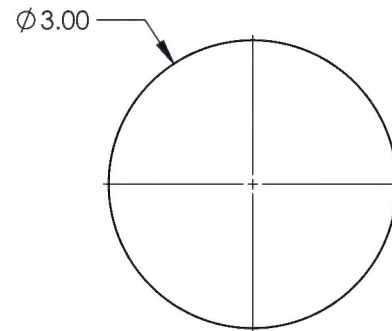
(-181)

PIVOT BRACKET

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-181	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .03 ANGLES ± 1°
DRAWN BY: GILBERT	.X ± .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
SCALE 1:2	BELL 212, 214B, 214ST, 412
DATE 3/13/2014	SHEET 28 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



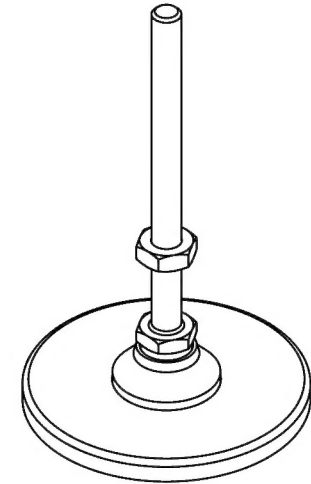
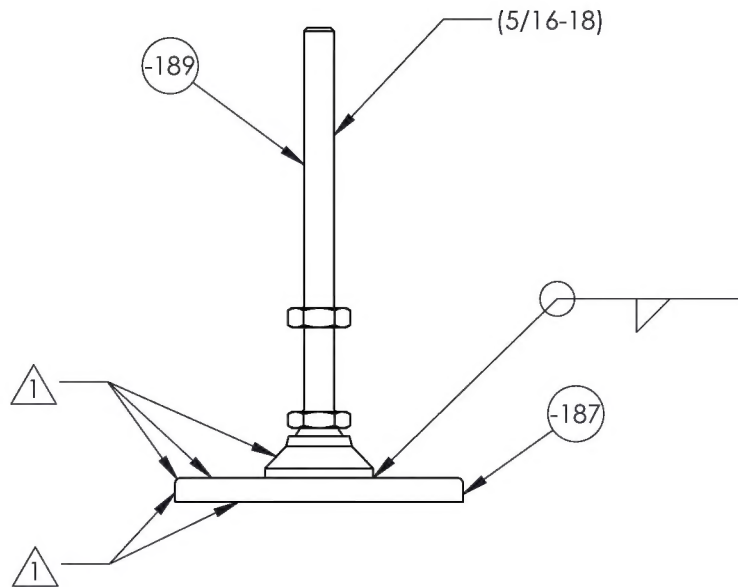
-183

RUBBER PAD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-183	REV 1
MAT'L RUBBER	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES
DRAWN BY: MACKOVJAK	.015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY
OPPS APPR: ANDERSON	AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER
APPROVED: GILBERT	ASME Y14.5M-2009
SCALE 1:2	DATE 7/13/2016
	SHEET 29 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



NOTE:

1 POWDER COAT YELLOW, SPEC: FED #13538.



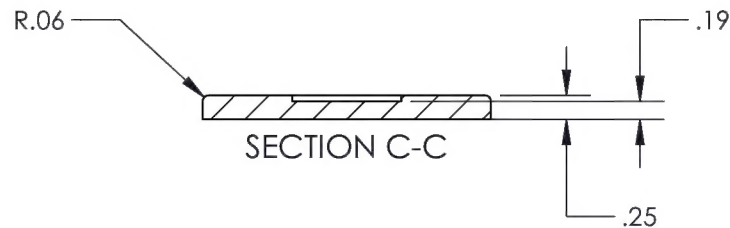
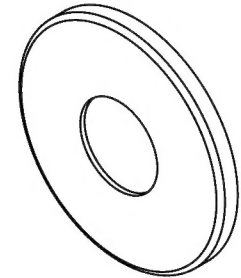
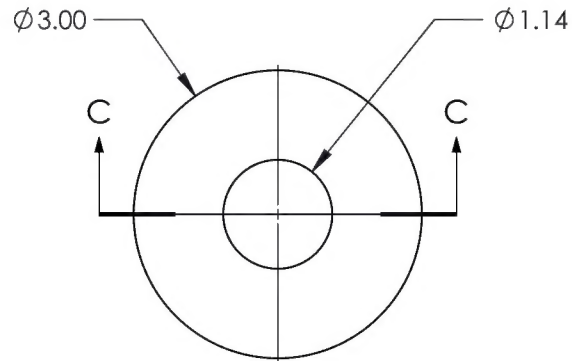
TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-185	
REV		1	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .010 FRACTIONS ± 1/8	
FINISH		.XX ± .03 ANGLES ± 1°	
SEE NOTES		.X ± .1 SURFACES = 125°	
SPEC		1. BREAK ALL SHARP EDGES	
DRAWN BY:		MACKOVJAK	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:2	
DATE		7/13/2016	
SHEET		30 OF 32	

-185

REST WELDMENT

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



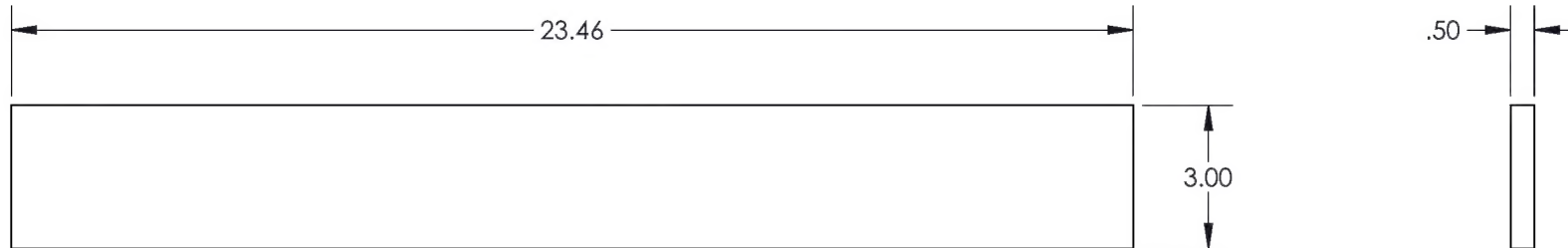
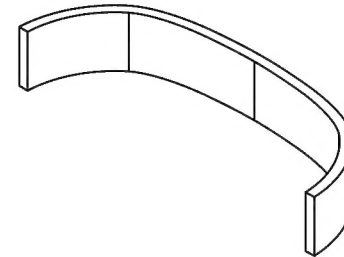
(-187)

REST WELDMENT PAD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-187	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -185 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 7/13/2016
	SHEET 31 OF 32

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-191)

CRADLE PAD

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-191	REV 1
MAT'L 17124	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
SCALE 1:4	ASME Y14.5M-2009
DATE 3/13/2014	USED ON MODEL
SHEET 32 OF 32	BELL 212, 214B, 214ST, 412